

Date: Monday, 9/10/2007 1:28:06 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG ASSEMBLY
Job Number : 34489	
Estimate Number : 11745	
P.O. Number :	Part Number : D3394043
This Issue : 9/10/2007 S.O. No. :	Drawing Number : D3394 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 34113	Material :
Written By :	Due Date : 9/21/2007 Qty: 40 Um: Each
Checked & Approved By : <u>9/27/09/11</u>	
Comment : Est Rev: A New Issue 06-01-06 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2423	Lug Extrusion
-----	-------	---------------



Comment: Qty.: 0.0735 f(s)/Unit Total : 2.9400 f(s)

D2423 Lug Extrusion

Batch: 33310

C 207/09/12

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut Blank to .850"

N/A cut at Netec

3.0	OUTSIDE SERVICE	OUTSIDE SERVICES
-----	-----------------	------------------



Comment: Sub-Contracting OUTSIDE SERVICES

Send Blanks To: Metec/Mast Precision Machining

P/O: 4557

Machine D3394-3 as per Dwg D3394

C 207/09/11 (40)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

C 27/9/27 (40)

5.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

C 27/9/26 (36) center

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:28:06 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 34489

Part Number: D3394043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(36x)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-f 07/04/27

7.0

POWDER COATING

POWDER COATING



(36)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL 07-09-28

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-10-01

9.0

MS3548993

GROMMET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS35489-93	Grommet	105792

7/10/1 SP

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3394

MF 07-10-01

(38)

11.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

En 07/10/01 (x36)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57473

07/10/2 (36)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



07.10.02 KY

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.10.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

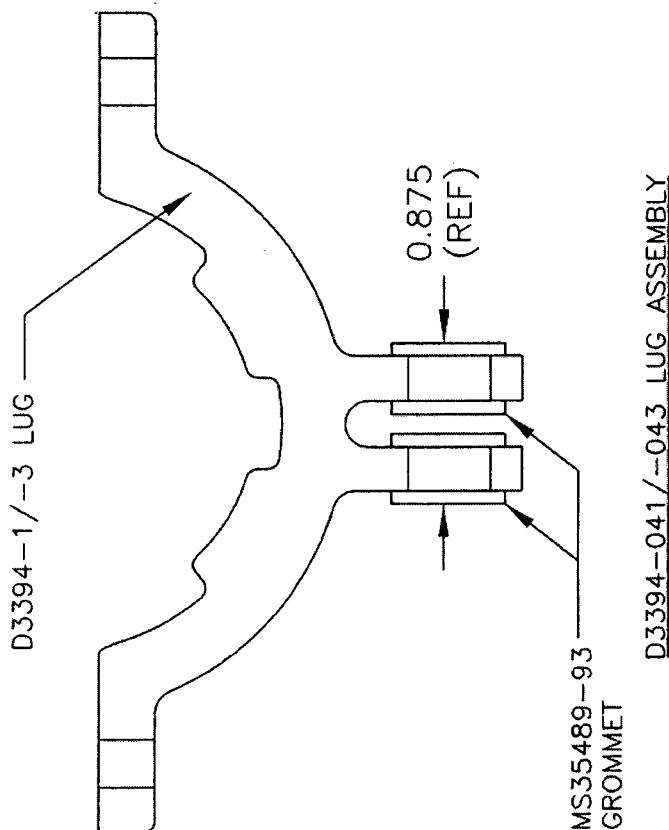
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3394	REV. A SHEET 1 OF 3
DATE 05.02.14		TITLE LUG	SCALE 1:1
A	05.02.14	NEW ISSUE	



**PARTS LIST FOR D3394-041/-043 LUG ASSEMBLY**

QTY -		QTY -	PART NUMBER	DESCRIPTION
041	X	043	D3394-041	LUG ASSEMBLY
		X	D3394-043	LUG ASSEMBLY
1			D3394-1	LUG
2		1	D3394-3	LUG
		2	MS35489-93	GROMMET

RELEASED

05.11.14

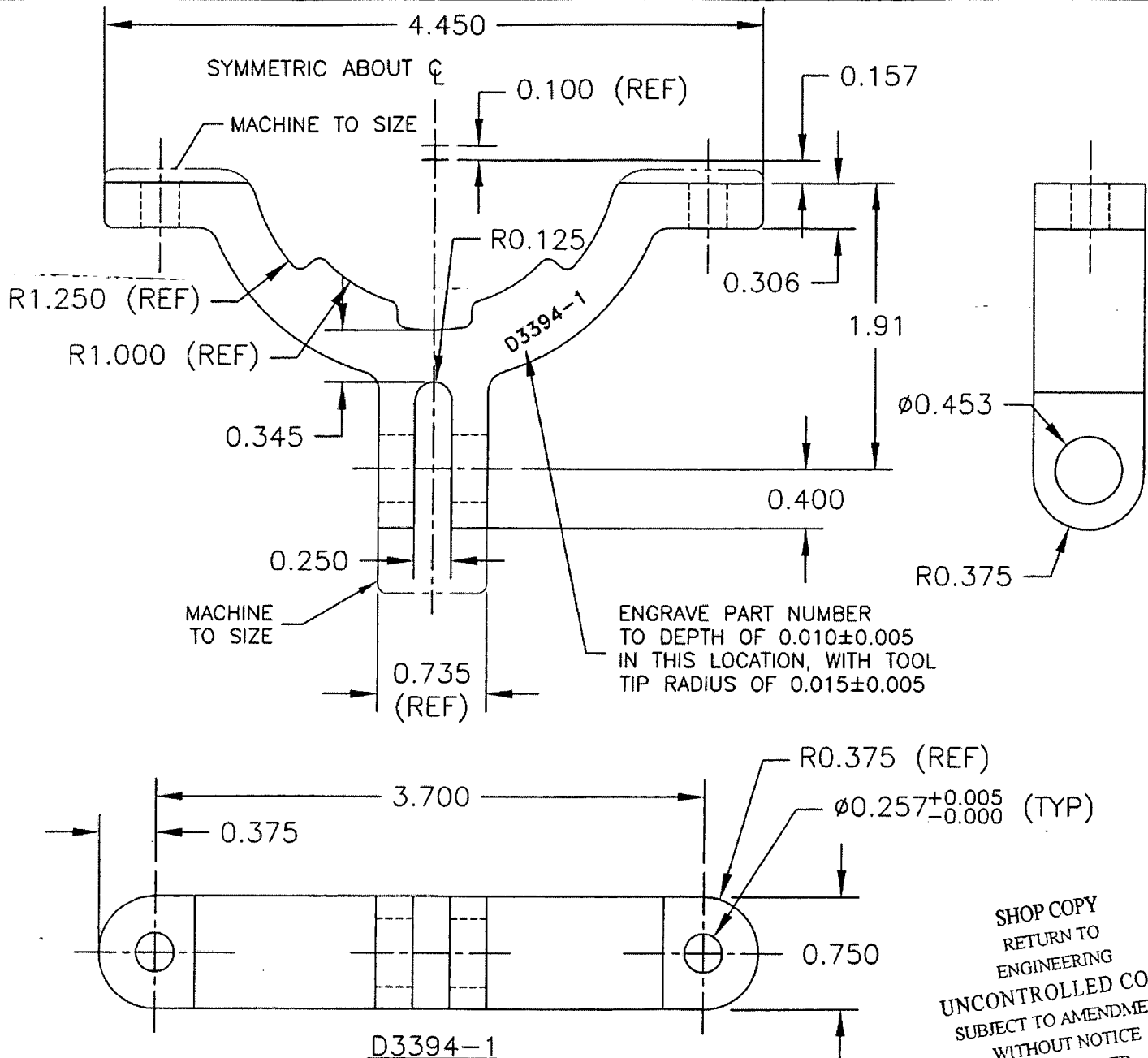
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WORK ORDER  
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3394	REV. A SHEET 2 OF 3
DATE 05.02.14		TITLE LUG	SCALE 1:1

**D3394-1 NOTES**

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 34789

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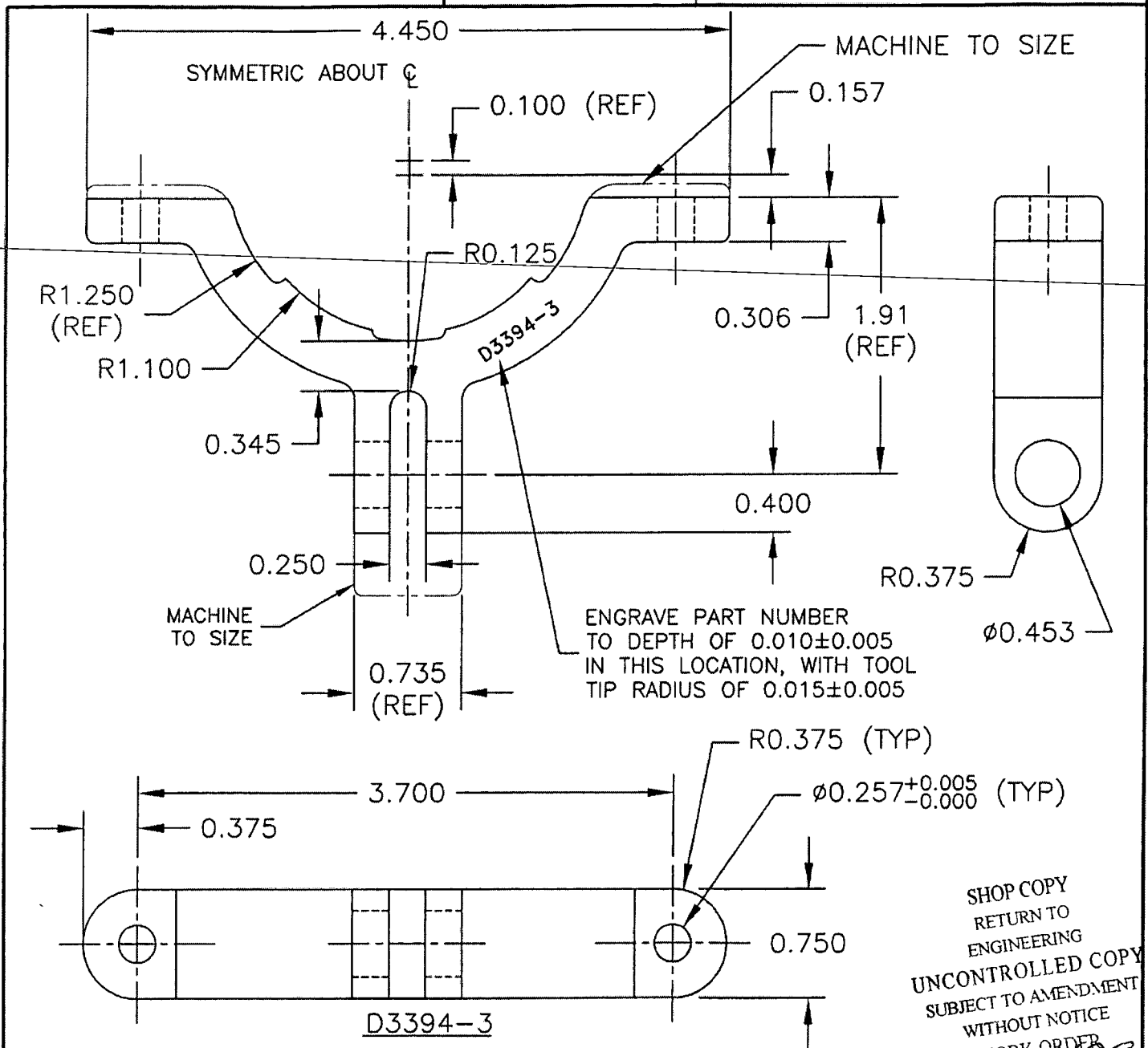
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3394	REV. A SHEET 3 OF 3
DATE 05.02.14	TITLE LUG		SCALE 1:1

**D3394-3 NOTES**

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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05-11-14

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## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

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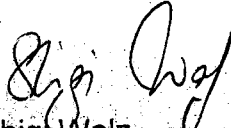
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
<del>40</del> 36	D3394-3	Lug B34489	4557
40	D3394-3	Lug B34488	4557

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shig Walz

Vankleek Hill, September 21, 2007